

31

Date: Thursday, 7/12/2007 10:40:54 AM.
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	FLOAT SKID ASSEMBLY		
Job Number	33526A					
Estimate Number	10756		Part Number	D412742043		
P.O. Number	N/A		Drawing Number	D3391 REV F		
This Issue	7/12/2007 S.O. No. N/A		Project Number	N/A		
Prsh Rev.	NC		Drawing Revision	F		
First Issue	N/A		Material	N/A		
Previous Run	33525A		Due Date	7/30/2007	Qty:	1 Um: Each
Written By						
Checked & Approved By	<u>DK</u> 07.07.12					
Comment	Est Rev A	05.10.13	New Issue	KJ/JLM		
	Est Rev B	06.02.13	ECN 773 dwg @ rev.D	EC		
	Est Rev:C	07-05-28	As per Rev F	JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
Comment: DOCUMENT CONTROL If D412-742-043 is a W/O on its own, Photocopy bluefile and create labels per PPP D412-742-043 CHG003			
2.0	D3391023	Mid Tube Assembly	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) pick: Qty Part Number Description Batch <u>1331845</u> <u>M1</u> 1 D3391-023 Mid Tube Assembly			
3.0	D3391025	Aft Tube Assembly	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) pick: Qty Part Number Description Batch <u>1333643</u> <u>esj</u> 1 D3391-025 Aft Tube Assembly			
4.0	D35641	WEARSHOE	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) WEARSHOE Batch: <u>B31417</u> <u>m.t</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/12/2007 10:40:54 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 33526A

Part Number: D412742043

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D35643 WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

B31419

m-h

6.0 D35645 WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

B33802

m-h

7.0 D35661 GASKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

Batch:

B33805

m-h

8.0 D35665 GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch:

B33483

m-k

9.0 AN3C4A BOLT



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

BOLT

Batch:

M105057

m-k

10.0 AN3C6A BOLT



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

BOLT

Batch:

M103693

m-k

11.0 AN3C7A BOLT



(1X)

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

Batch:

M103668

m-l 07/08/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/12/2007 10:40:54 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 33526A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN960C10L

washer



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

washer

Batch:

M105143

M.D.

13.0

HAND FINISHING

HAND FINISHING RESOURCE #1



(1X)

Comment: HAND FINISHING RESOURCE #1

1-Spray inside tube of D3391-021/-023/-025 with LPS-3 as per Dwg D3391

A/R LPS-3

M104161

2-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.

A/R Sikaflex-241-291

Expiry date:

M104989

08-01

3-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Coat bolts with LPS "procyon".

Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.

A/R LPS Procyon

M1041251

A/R Sikaflex-241-291

M104989

Expiry date:

08-01

4-Remove "T" pins once sikaflex is dry.

5-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

M.D.
07/08/20

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-043

Location:

PPP Rev:

PPP 33564

07/08/2010

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 04/08/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/12/2007 10:40:54 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 33526A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC21

FINAL INSPECTION/W/O RELEASE



(1)

Comment: FINAL INSPECTION/W/O RELEASE

7/12/07

Job Completion



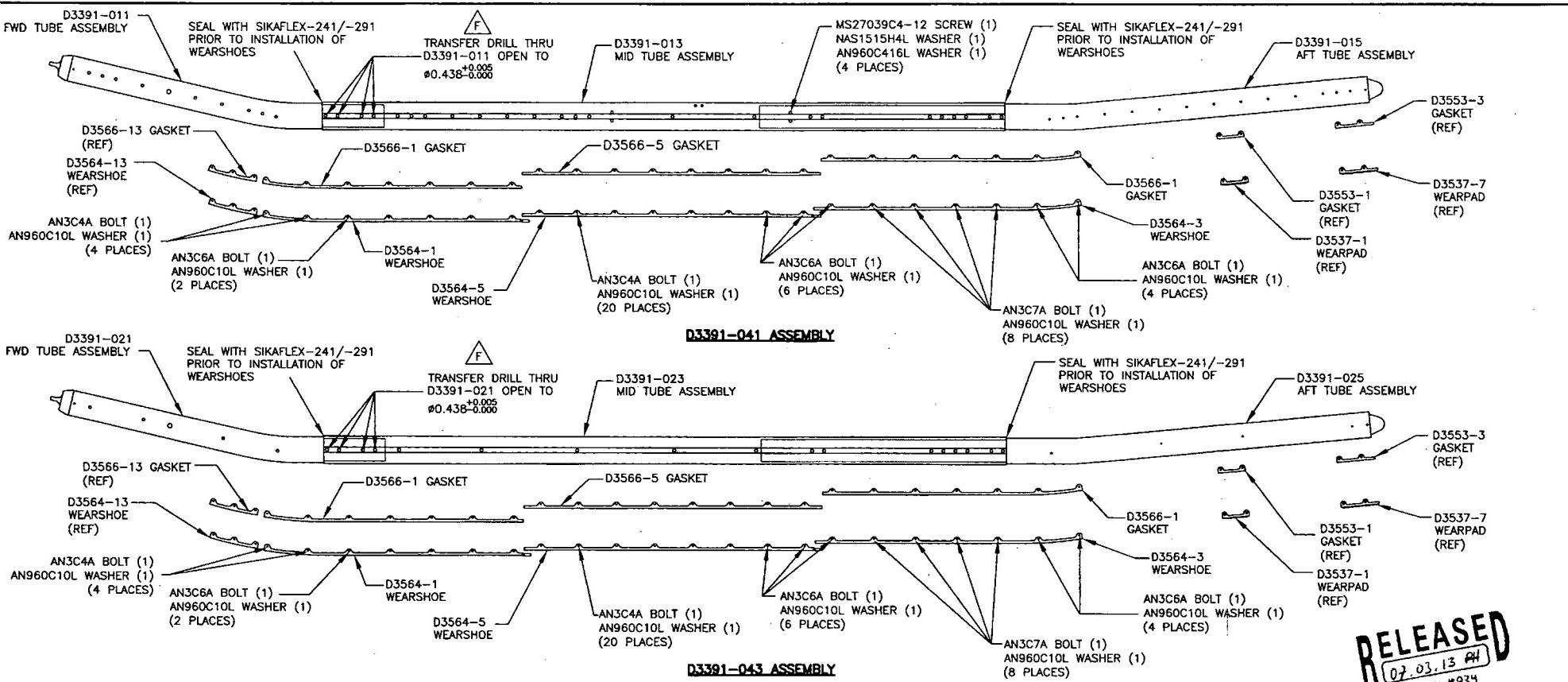
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3391-041 ASSEMBLY

D3391-043 ASSEMBLY

RELEASED
07.03.13 PH
per E&N #934

D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
24	24	D3391-041	FLOAT SKIDTUBE ASSEMBLY
X	-043	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	1	D3391-011	FWD TUBE ASSEMBLY
1	1	D3391-013	MID TUBE ASSEMBLY
1	1	D3391-015	AFT TUBE ASSEMBLY
1	1	D3391-021	FWD TUBE ASSEMBLY
1	1	D3391-023	MID TUBE ASSEMBLY
1	1	D3391-025	AFT TUBE ASSEMBLY
1	1	D3564-1	WEARSHOE
1	1	D3564-3	WEARSHOE
1	1	D3564-5	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	AN960C10L	WASHER
4	4	MS27039C4-12	SCREW
4	4	NA5151H4L	WASHER
4	4	AN960C416L	WASHER

GENERAL NOTES

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 5) USE DART DRILL TEMPLATE DTB217 TO LOCATE AND DRILL 'E' SIZE HOLES ($\phi 0.250 - \phi 0.257$) FOR WEARSHOE INSERTS. C-SINK $\phi 0.391 / \phi 0.425 \times 100^\circ$ AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.

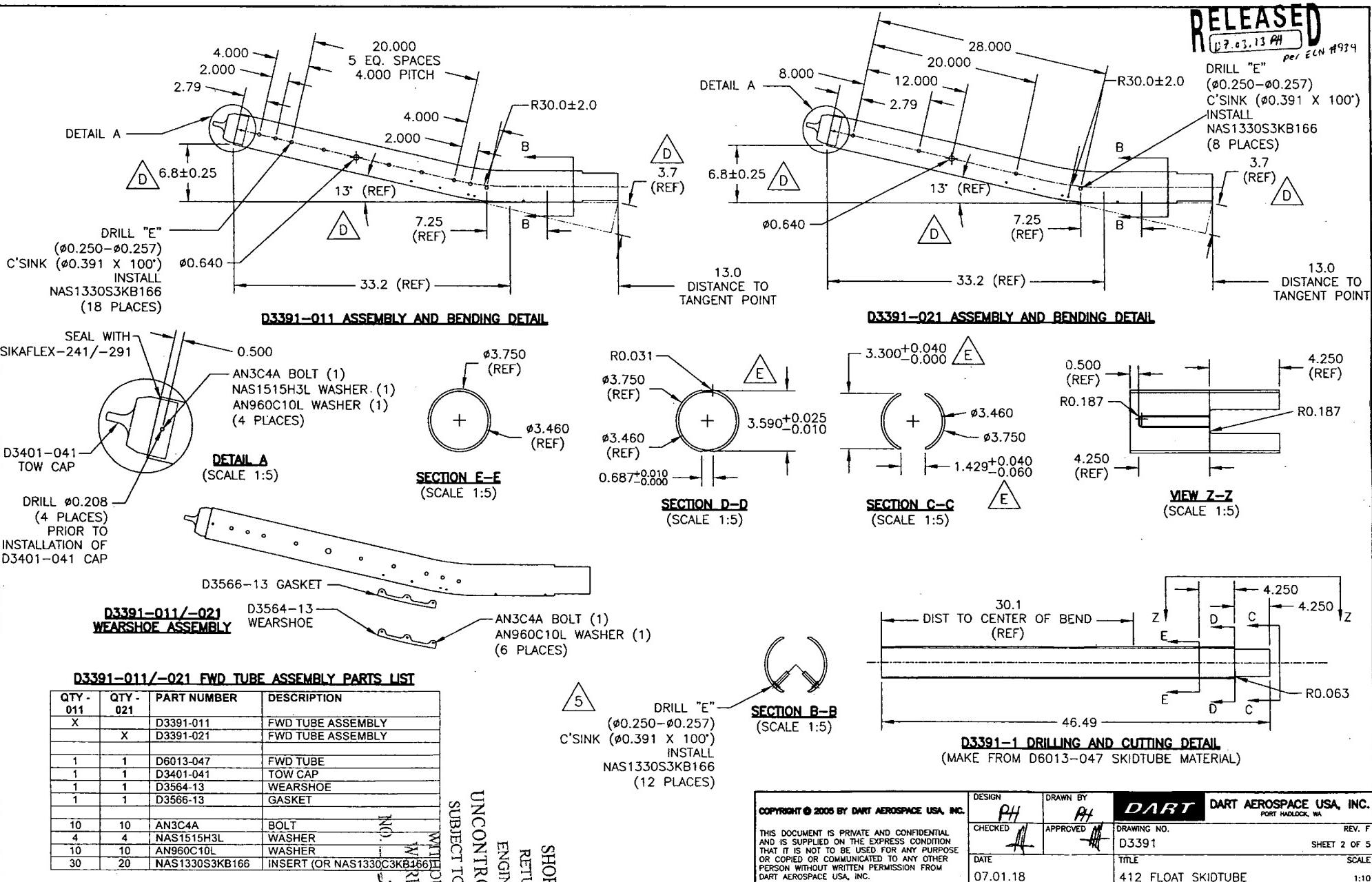
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32526A
ENGINEERING
RETURN TO
SHOP COPY

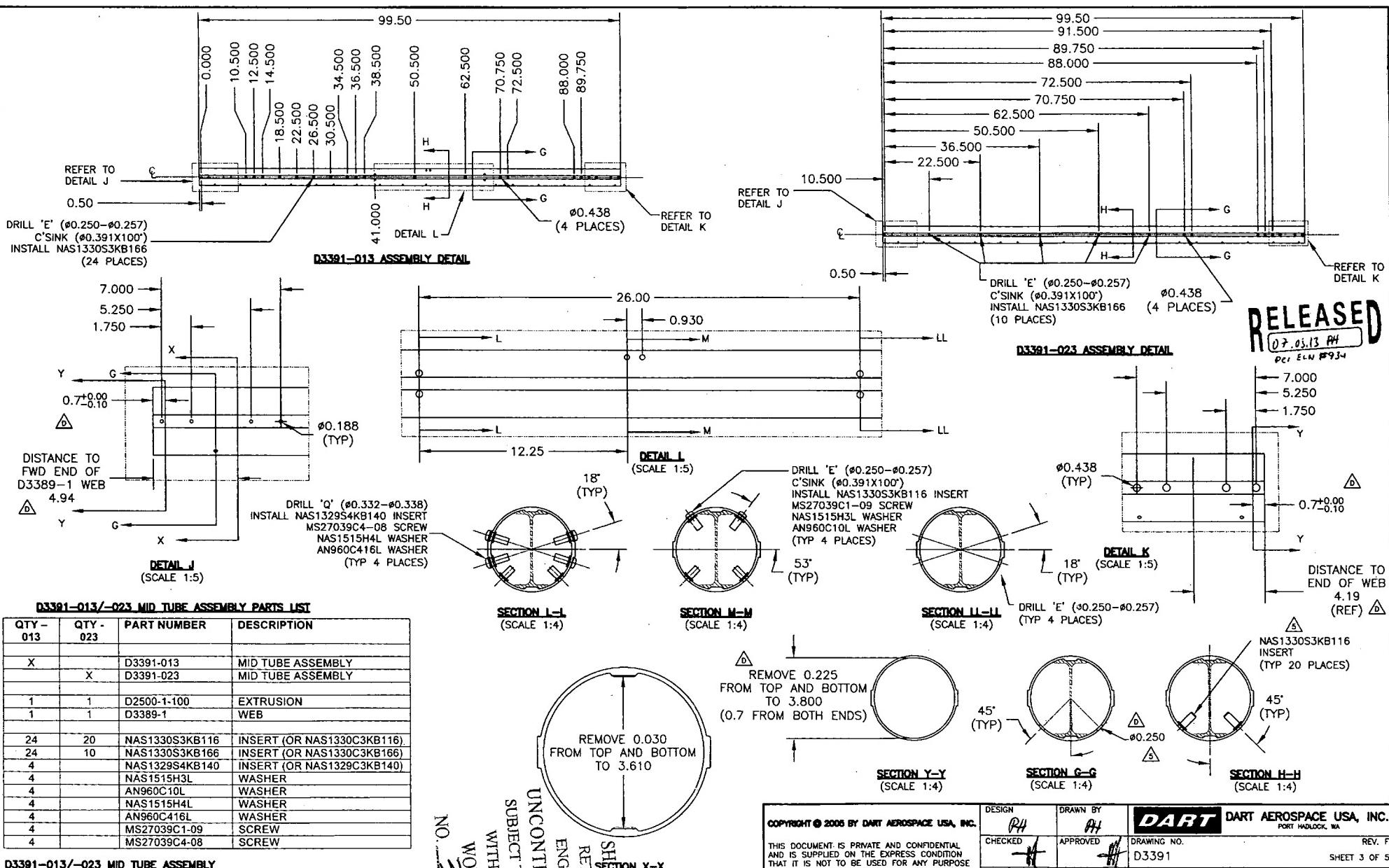
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DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3391	REV. F SHEET 1 OF 5
DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	SCALE NTS	

RELEASED
17.03.13 AM
per ECN A934

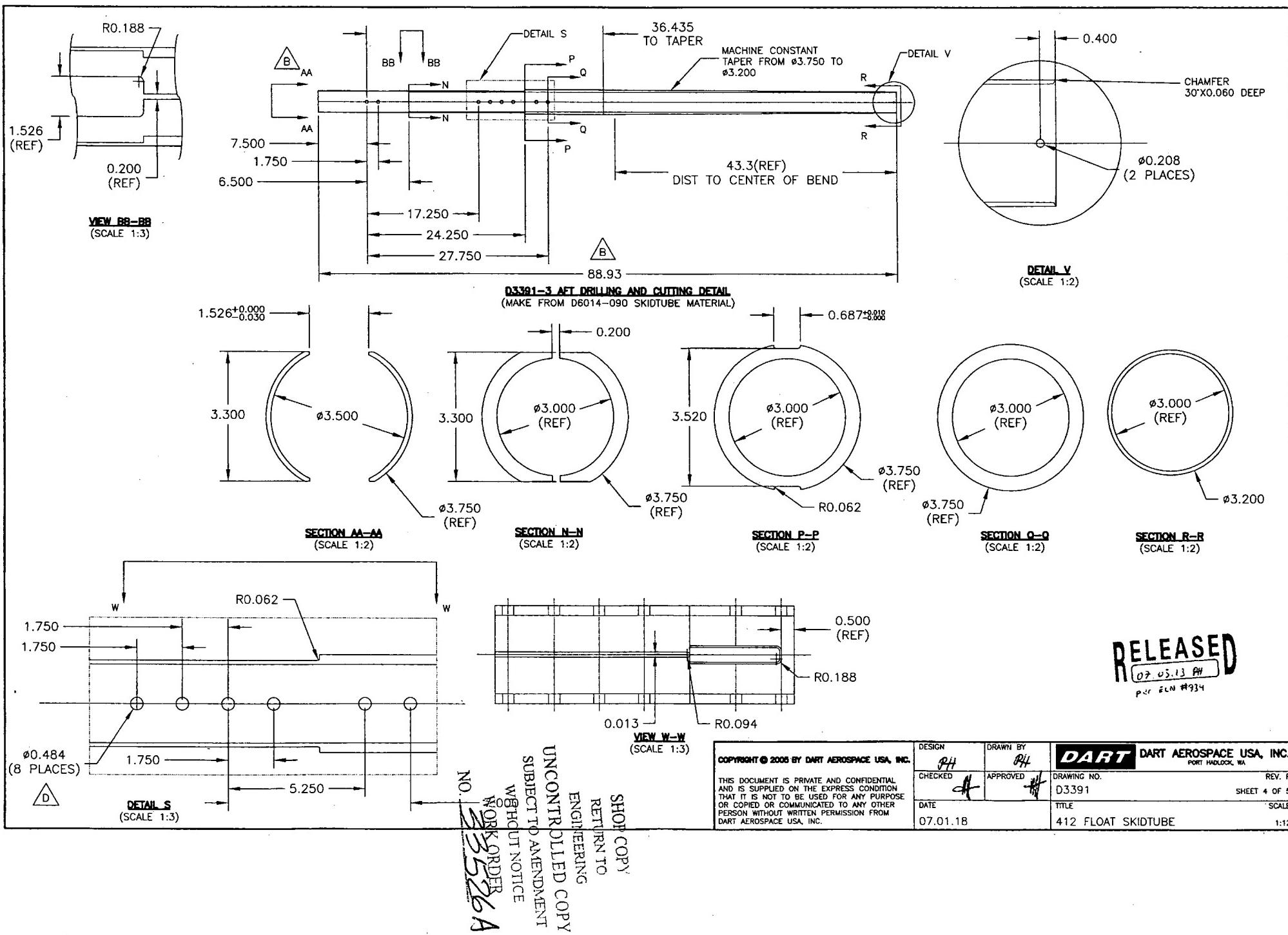


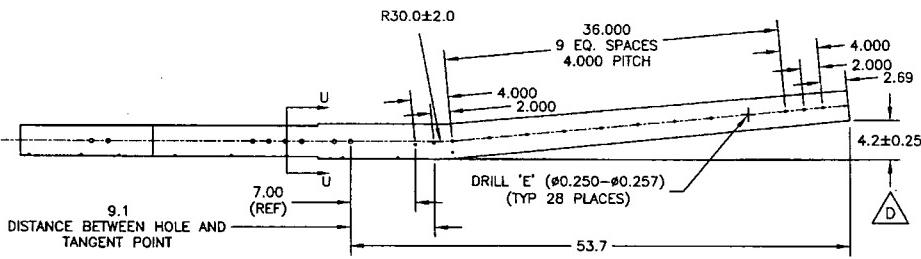


D3391-013/-023 MID TUBE ASSEMBLY

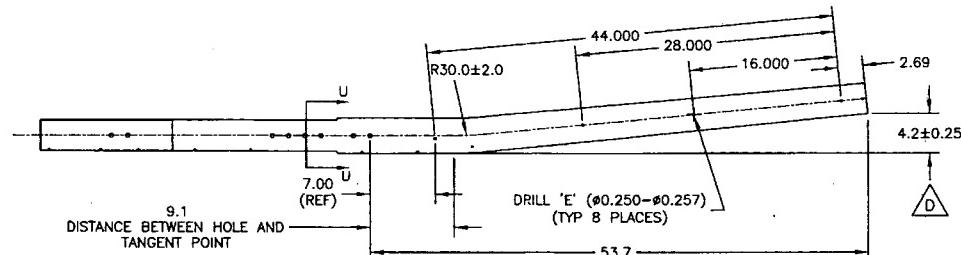
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
 - 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER

SECTION X-1
(SCALE 1:2)
SECTION X-1
COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDERED
NO. 33526A

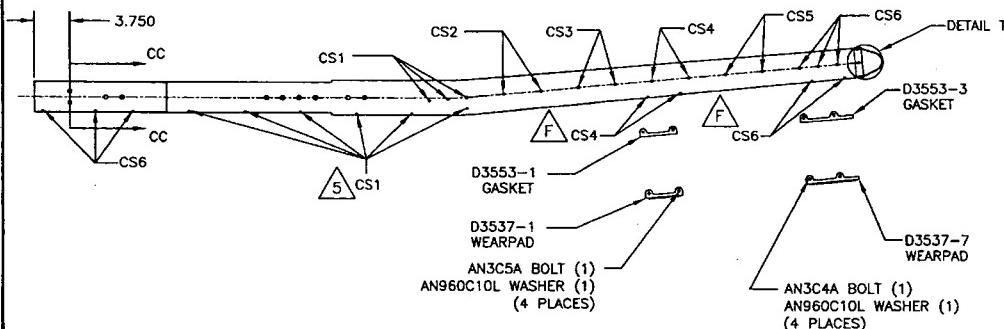




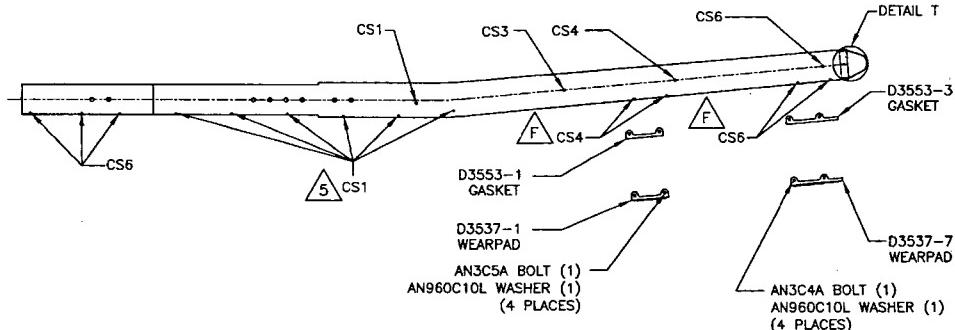
D3391-015 BENDING AND ASSEMBLY DETAIL.



D3391-025 BENDING AND ASSEMBLY DETAIL.



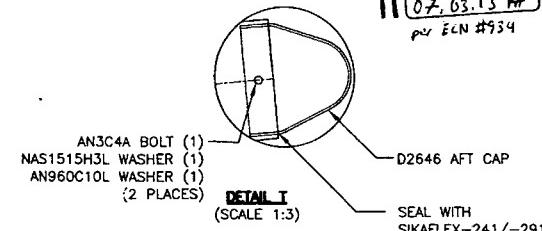
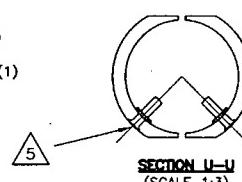
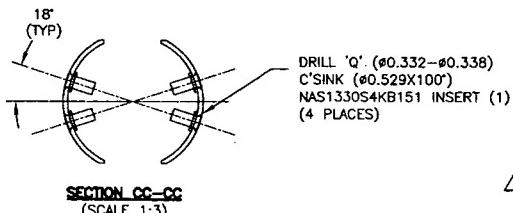
D3391-015 INSERT AND WEARPAD INSTALLATION DETAIL.
(SEE TABLE)



D3391-025 INSERT AND WEARPAD INSTALLATION DETAIL.
(SEE TABLE)

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	D3391-015	AFT TUBE ASSEMBLY	
X	D3391-025	AFT TUBE ASSEMBLY	
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
18	14	NAS1330S3KB366	INSERT (OR AES10KB366)
4	2	NAS1330S3KB316	INSERT (OR NAS1330C3KB316)
8	6	NAS1330S3KB266	INSERT (OR NAS1330C3KB266)
4	4	NAS1330S3KB216	INSERT (OR NAS1330C3KB216)
16	12	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4	4	NAS1330S4KB151	INSERT (OR NAS1330C4KB151)
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
2	2	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER



C'SINK AND INSTALL NAS1330S3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'SINK	P/N
CS1	18	14	Ø0.425	NAS1330S3KB366
CS2	4		Ø0.391	NAS1330S3KB366
CS3		2	Ø0.391	NAS1330S3KB316
CS4	8	7	Ø0.391	NAS1330S3KB266
CS5	4	4	Ø0.391	NAS1330S3KB216
CS6	16	12	Ø0.391	NAS1330S3KB166

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DESIGN PH DRAWN BY BH
CHECKED / APPROVED /
DATE 07.01.18

DART AEROSPACE USA, INC.
PORT HUDDLE, MA
DRAWING NO. D3391
REV. F
SHEET 5 OF 5
TITLE 412 FLOAT SKIDTUBE
SCALE 1:12

WORK ORDER
JUN 2005
TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY